

Work Order ID 137360

September 25, 2015 8:54:10 AM

D 4840-041

137360

Page 1

Need Oct 27

Item ID: D4840-041
Revision ID:
Item Name: Upper Cutter Assembly

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Start Date: 9/25/2015 Start Qty: 6.00 *6*
Required Date: 10/22/2015 Req'd Qty: 6.00 *6*

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: SH Date: 20150925 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4840	REV A								

110 Pick Kit 0.00

110

Packaging Memo 0.00
Packaging

NOV 09 2015 DAS 6 9-89

120 0.00

120

Small Fab Memo 0.00
Small Fab Assemble as per dwg and apply loctite 598 on all faying surfaces.
A/R LOCTITE 598: 1133436

Cox 15/11/13 DAS 36 9-89

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00
Quality Control

DAS 38 9-89

NOV 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 137360***137360***

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Item ID: D4840-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 9/25/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/22/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CK045</u>	0.00							
140									
Packaging	Memo	0.00							<u>046</u> <u>6</u> <u>28</u>
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MLJ 15-11-13
ME 15-11-13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : ☐																									

Picklist Print

September 25, 2015 8:54:15 AM

Page 1

Work Order ID: 137360

137360

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 9/25/2015

Required Date: 10/22/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4823-1

Manufactured

No

Each

6.0000

6

DAS

6

9-89

D4823-1

Upper Cutter Deflector

**

Location

Loc Qty

Loc Code

cck127

6

105011

4

109244

2

D4824-1

Manufactured

No

Each

1.0000

6

DAS

6

9-89

D4824-1

Upper Cutter Mount

**

Location

Loc Qty

Loc Code

cck127

1

109245

1

D4838-2

Manufactured

No

Each

1.0000

6

DAS

6

9-89

D4838-2

Upper Cutter Body, RH

**

Location

Loc Qty

Loc Code

CCK128

1

109247

1

D4838-1

Manufactured

No

Each

2.0000

6

DAS

6

9-89

D4838-1

Upper Cutter Body, LH

**

Location

Loc Qty

Loc Code

CCK128

2

133526

2

DAS
36
9-89

B137388 (3x)

23

6

137369 X4

2

6

137320 X5

1

6

137371

2

NOV 09 2015

Picklist Print

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Work Order ID: 137360

137360

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 9/25/2015

Required Date: 10/22/2015

Start Qty: 6.00

Required Qty: 6.00

D4839-1 Manufactured No

Each 7.0000

12

DAS

D4839-1

**

137690 X 12

8

Blade

9-89

Location

Loc Qty

Loc Code

CCK128

7

134649

7

MS27039-08-19

Purchased No

Each 562.0000

84

DAS

MS27039-08-19

**

Screw

8

Location

Loc Qty

Loc Code

GA

250

m132930

250

ST260a

100

m133077

100

ST273A

183

m131317

183

ST281

29

m131264

29

NAS1149FN832P

Purchased No

Each 1,949.000

168

DAS

NAS1149FN832P

**

Washer

6

8-89

Location

Loc Qty

Loc Code

GA

737

125268

737

ST260a

291

125268

291

st268

921

M130388

921

NOV 09 2015

53

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Shop Packet Print

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Picklist Print

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Work Order ID: 137360

137360

Parent Item: D4840-041

D4840-041

Parent Item Name: Upper Cutter Assembly

Start Date: 9/25/2015

Required Date: 10/22/2015

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Purchased

No

Each

812.0000

84

MS21042L 08

Nut

**

133523

80

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

300

m133134

300

ST304

411

123900

16

m128401

102

m128429

3

m131317

62

m132930

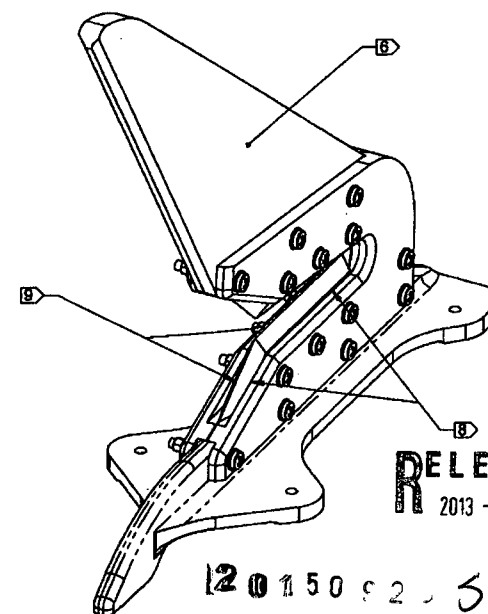
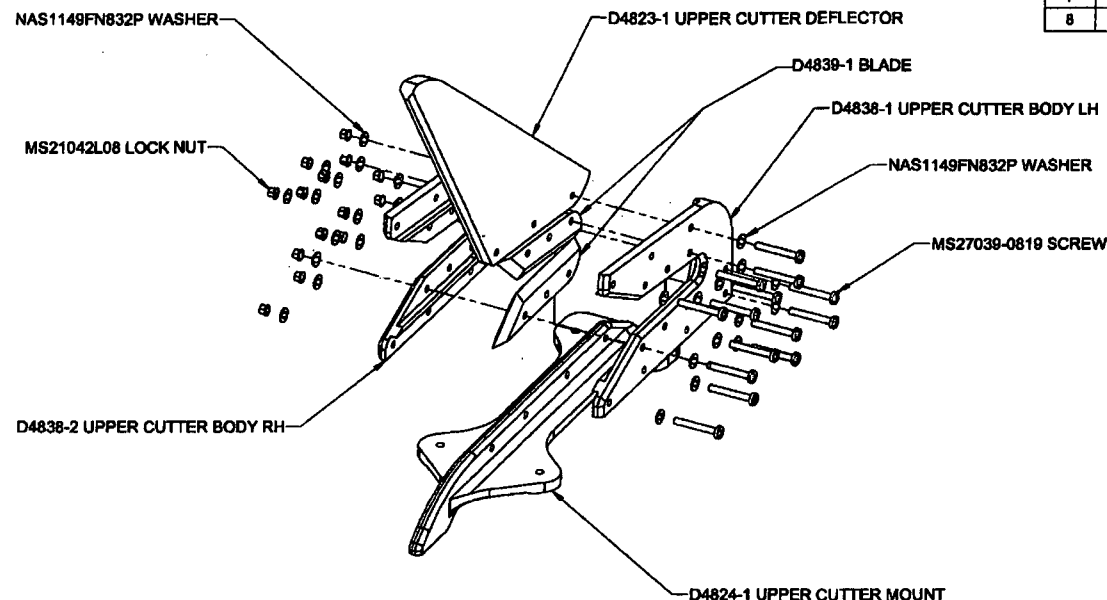
228

7 15/11/10 DAS 36 9-89

NOV 09 2015

8 9 6

ITEM	QTY -041	P/N	DESCRIPTION
1	1	D4823-1	UPPER CUTTER DEFLECTOR
2	1	D4824-1	UPPER CUTTER MOUNT
3	1	D4838-1	UPPER CUTTER BODY LH
4	1	D4838-2	UPPER CUTTER BODY RH
5	2	D4839-1	BLADE
6	28	NAS1149FN832P	WASHER (AN980C10)
7	14	MS27039-0819	SCREW
8	14	MS21042L08	LOCKNUT



RELEASED
2013-07-12

D4840-041 UPPER CUTTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4840-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 3.77 LBS (1.63 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

20150925

A		NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	DB			SHEET 1 OF 1	
CHECKED	AP			D4840	
MFG. APPR.	AP			TITLE	
APPROVED	AP	UPPER CUTTER ASSY		SCALE	NTS
DE APPR.	AP	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			
DATE	13.05.23				